

Work Order ID 146147

Friday, May 06, 2016 11:34:12 AM

146147

Page 1

Item ID: D3256-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

POSITIVE
RECALL

Stop ***NS2***

Item Name: Gasket

Start Date: 5/6/2016 Start Qty: **190** ***2***

Cust Item ID:

Required Date: 5/10/2016 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: UNE Date: 16-5-5 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3256	E

100	FLOW WATER JET	0.00							
100									
Waterjet									

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3256

Rev: _____

Prog Rev: _____

DAS 22 9-88
16.05.06 0.26
customer see attached email

(6) 05/16/09

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--

110

QC

Memo

Quality Control

(6) 05/16/09

120	QC8- Inspect parts - second check	0.00							
-----	-----------------------------------	------	--	--	--	--	--	--	--

120

QC

Memo

Quality Control

(6) 05/16/09
DAS 38 9-88

MAY 10 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY					
Environment ☐		No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐		Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐		Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐		Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐		Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐		Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐		Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐		Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐		Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐		Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐		Manufacturing Process ☐	OTHER : _____					
Misidentified ☐		Past Due ☐						

Work Order ID 146147

Friday, May 06, 2016 11:34:12 AM

146147

Page 2

Item ID: D3256-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gasket

Start Date: 5/6/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/10/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: Lat

0.00

130

Packaging

Memo

0.02

Packaging

DAS

6

9-09

MAY 6 0 AM

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.20

Quality Control

MCS

MAY 10 2016

MCS

MAY 10 2016

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
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Picklist Print

Friday, May 06, 2016 11:34:11 AM

Page 1

Work Order ID: 146147

146147

Parent Item: D3256-3

D3256-3

Parent Item Name: Gasket

Start Date: 5/6/2016

Required Date: 5/10/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP B04.12.06Made in-houseKJ/JLM
IPP Rev:C ecn 1052/water jet 07-11-05 DD verified by:EC IPP REV:D
12.11.07 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

G89		Purchased	No			100	sf	0.0000	1.02	2.147368			
-----	--	-----------	----	--	--	-----	----	--------	------	----------	--	--	--

G89
Coated Cloth

Dell 6/05/09

D3245

132665

8.3

DQA: _____ Date: _____

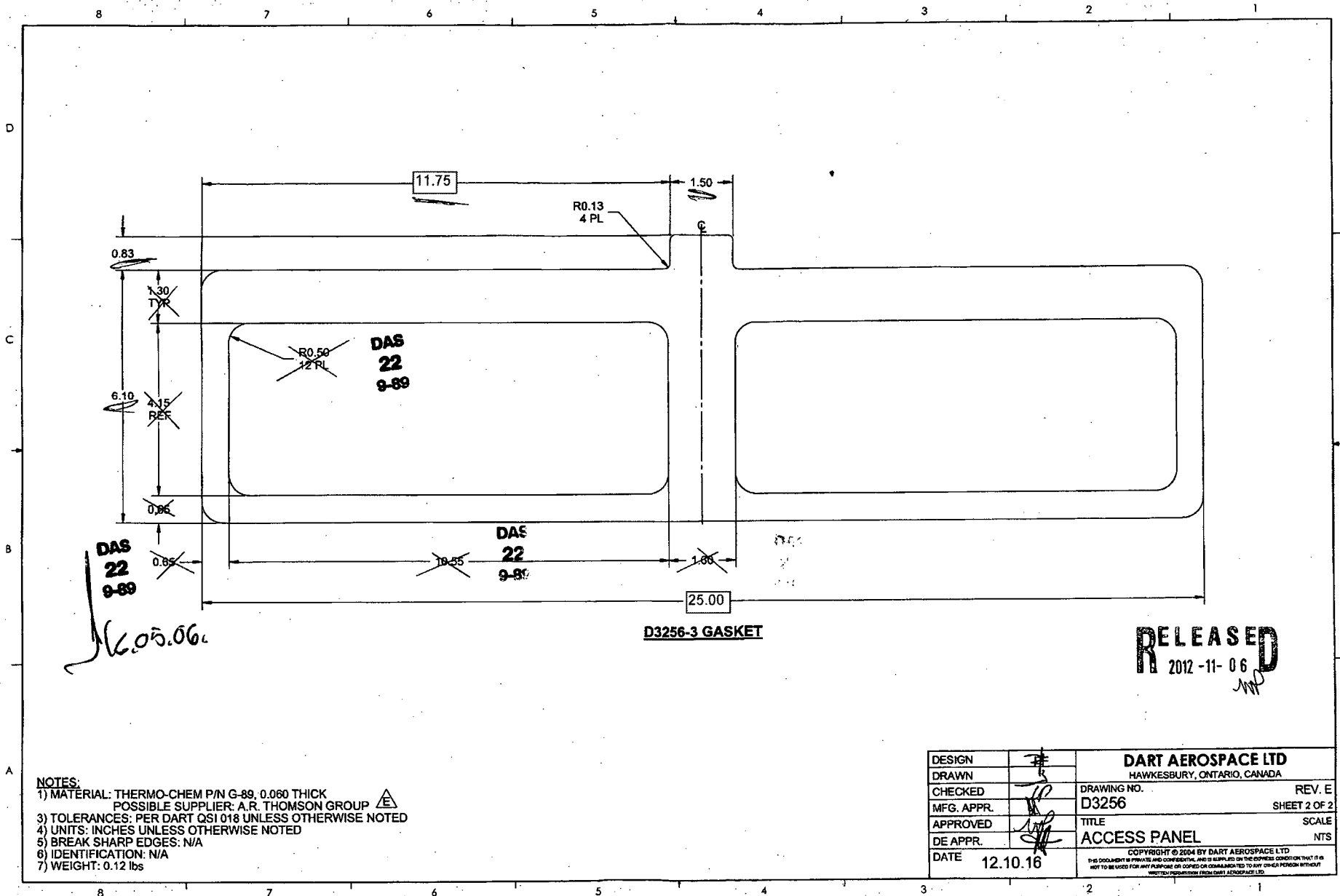


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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
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								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
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OTHER : _____									



RELEASED
2012-11-06

NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89, 0.060 THICK
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3256	REV. E
MFG. APPR.		SHEET 2 OF 2	
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL	NTS
DATE	12.10.16	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Melanie Fauteux

From: Marc Bellavance
Sent: Friday, May 06, 2016 11:22 AM
To: Melanie Fauteux
Cc: Shirley Hay; Denis Maranda; Sian Willems
Subject: FW: Supporting Bell Helicopter
Attachments: D3256-1_RevPF1.pdf; D3256-1F_RevPF1.dxf; D3256-3 RevE_CUSTOM.pdf; D3256-3 RevE_CUSTOM.dxf; D3206_RevPB1.pdf; D3206-3F_RevPB1.dxf

Importance: High

Hi Mel,

As discussed, please see below.

Also:

1. Just got off the phone with Bell and D412-705-015 should be put under review and any WIP on hold if not done already. This kit is not working on Bell 412 EPI and tweaks are required. As a result, Bell would now need:
 - Qty(1) D3256-1 per attached drawing and DXF.
 - Qty(2) D3256-3 per attached drawing and DXF.
 - This would ensure they can complete ships 1 and 2. Based on this, other 5 kits would need to be amended accordingly but this is still TBD.
2. D412-704-015 Kit: some tweaks required for fit on Bell 412 EPI. Next revision of this kit will add D3206-3. We have already provided them with qty(1) on prelim and they confirm resolution of the issue (SO125967). They have 7 ships so we would need to make qty(6). If possible, qty(1) required for next week. Drawing and DXF attached.

Same as recently, I would be delivering the parts. Next visit is scheduled for May 10 but I don't mind pushing it back to May 13.

Please let me know what is possible to do here. If a meeting is required then please let's have one. ☺

Thanks,
Marc

From: Marc Bellavance
Sent: May-06-16 8:44 AM
To: Denis Maranda <dmaranda@dartaero.com>
Cc: Sian Willems <swillems@dartaero.com>; Patrick Smith <psmith@dartaero.com>
Subject: FW: Supporting Bell Helicopter
Importance: High

Hi Denis,

I will have to put a no charge in our system for this; please advise.

Thanks,
Marc

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

From: Marc Bellavance
Sent: May-05-16 2:40 PM
To: Denis Maranda <dmaranda@dartaero.com>
Cc: Sian Willems <swillems@dartaero.com>; Patrick Smith <psmith@dartaero.com>
Subject: Supporting Bell Helicopter
Importance: High

Hi Denis,

Following my visit to Bell last week, work continued on the D3256-1/-3 we provided them with. However, it was brought to my attention that they have scrapped D3256-3 Gasket while trying to install it on the aircraft. Bell was asking for a "blank" version which they could trim as required. See attached what the custom part would look like.

Sian agreed to the replacement at no charge. We would also require a second blank part for our own reverse engineering purposes. My next visit to Bell is scheduled for the morning of Tuesday, May 10.

Does this give you enough time to have the part manufactured?

Marc Bellavance
Mechanical Designer / Technical Support

DART AEROSPACE
T 1 613 632 5200 > 243
M 1 613 676 0992
F 1 613 632 9311
S marcbellavance
www.dartaerospace.com



Technical Publications: Verify Revision Status/Download [HERE!](#)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

